

Work Order ID 95704

January-18-13 9:58:09 AM

95704

Page 1

Item ID: D2228

**D 2 2 2 8
B 9 5 7 0 4**

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket Plate

Start Date: 1/16/13

Start Qty: 20.00

~~20~~
~~20~~ * 36 *

Cust Item ID:

Required Date: 2/01/13

Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-18 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2228	Rev B	0.00							
100	FLOW WATER-JET								
100 Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2228 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary.								
5052 .063									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS 27 9-89						
120 QC	Memo	0.00	131016						
Quality Control			80 Count						

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend		Grain		Ovalized		Pressure/Forced				
Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld				
Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
Cuffs	Contamination		Maintenance		Part Moved						
Heat Treat	Countersink		Mislabeled		Positioned Wrong						
Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge						
Ripples in Bend	Drill Holes		Offset								
Torque Waves in Extrusion	Drawing		Out of Calibration								
Turning Sequence	Finish		Out of Sequence								
Wave/Twist in Tube	Folio		Outside Dimensions								

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Page 2

Item ID: D2228

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket Plate

Stop

NS2

Start Date: 1/16/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/01/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish	Chemical Conversion Coat per QSI005 4.1 Memo	0.00							40 NG 13-10-16
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 126125 Memo START TIME: 7:40 FINISH TIME: 8:10 OVEN TEMPERATURE: 300	0.00							40 φ 13-10-17.
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00	DAS 27 9-89						40

DAS
34
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Setup	<input type="checkbox"/>										
Other	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										
FAULT CATEGORY											
Landing Gear			General								
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced			
Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure			
Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld			
Crushed/Crimped.	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled			
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>				
Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>				
Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>	Other	<input type="checkbox"/>				
Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>				
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>				
Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>				

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Item ID: D2228

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Plate

Stop

NS2

Start Date: 1/16/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/01/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: ST007

0.00

160

Packaging

Packaging

40

DAS

33

9-89

137048

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.00

13/10/2013

pl B-10-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General		Grain		Ovalized		Pressure/Forced				
Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld				
Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
Cuffs	Contamination		Maintenance		Part Moved						
Heat Treat	Countersink		Mislabeled		Positioned Wrong						
Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge						
Ripples in Bend	Drill Holes		Offset								
Torque Waves in Extrusion	Drawing		Out of Calibration								
Turning Sequence	Finish		Out of Sequence								
Wave/Twist in Tube	Folio		Outside Dimensions								

Picklist Print

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Page 1
1

Work Order ID: 95704

Parent Item: D2228

Parent Item Name: Bracket Plate

Start Date: 1/16/13

Required Date: 2/01/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B00.08.22Re-formatEC
IPP C 07.03.20 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063 5052-H32 .063 Sheet		Purchased	No			100	sf	94.8053	0.0227	0.454		Ae 13.10.16	

Location	Loc Qty	Loc Code
MAT022	94.805264	
114322	25.705264	
<u>120603</u>	38	
121901	31.1	

120603 → .81

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS										
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other									
Part No. _____																
NCR No. _____																
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	General			Bend	General			Grain	General			Ovalized	General			Pressure/Forced
Centre Not Concentric to O/S				BOM/Route				Hardware				Over/Under tolerance				Temperature/Cure
Cracks				Broken/Damaged				Inspection Incomplete				Part Incorrect				Weld
Crushed/Crimped				Burrs				Instructions Incomplete/Unclear				Part Lost/Missing				Wrong Stock Pulled
Cuffs				Contamination				Maintenance				Part Moved				
Heat Treat				Countersink				Mislabeled				Positioned Wrong				
Inspection Strip in Tube				Cut Too Short				Misread				Power Loss/Surge				
Ripples in Bend				Drill Holes				Offset								
Torque Waves in Extrusion				Drawing				Out of Calibration								
Turning Sequence				Finish				Out of Sequence								
Wave/Twist in Tube				Folio				Outside Dimensions								

DART AEROSPACE LTD	Work Order:	95704
Description: Backing Plate	Part Number:	D2228
Inspection Dwg: D2228	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

Measured by:	<u>Ak</u>	Audited by:	<u>27</u> <u>9-89</u>	Prototype Approval:	N/A
Date:	<u>13.10.16</u>	Date:	<u>13.10.16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	M

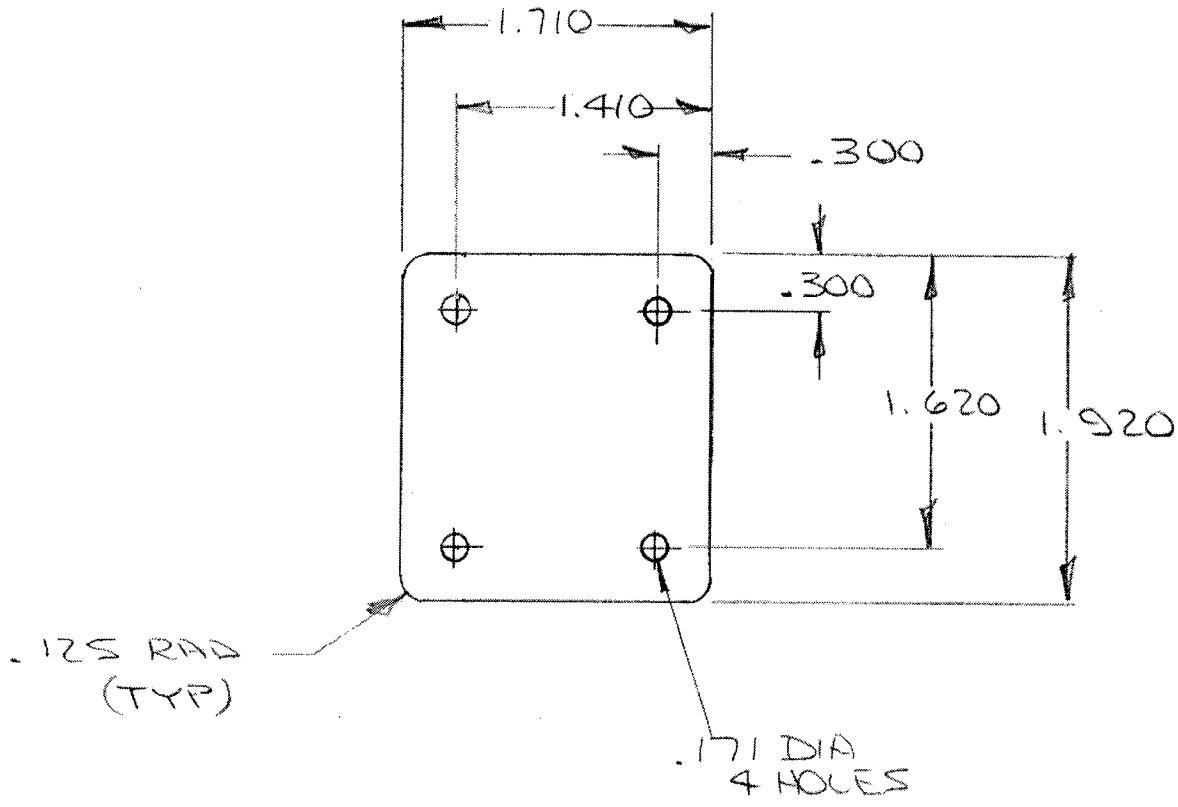
DART



DRAWN BRADLEY 94.3.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.27	DRAWING NO. D2228	REV. B SHEET 1 OF 1
STRESS	TITLE BACKING PLATE	

RELEASED
00.09.11

B	00.09.11	UPDATE FINISH SPEC. & UP
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MATERIAL: 5052-H32 .063 THICK
(QQ-A-250/8)

FINISH: ▲ CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

NO. OF PAGES 1
PAGES ISSUED
ENCL. DRAWING
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WITH EXC. SUBJECT
WORK ORDER
10-2957-04MUT
13-01-18